

Date: Friday, 9/29/2006 10:43:19 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP LEG
Job Number :	28791B		
Estimate Number :	10353		
P.O. Number :	N/A	Part Number :	D2278
This Issue :	9/29/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2278 REV E
First Issue :	N/A	Project Number :	N/A
Previous Run :	27756B	Drawing Revision :	E
	Type : SMALL /MED FAB	Material :	N/A
Written By :		Due Date :	10/10/2006
Checked & Approved By :	Qty:		40 Um: Each
Comment :	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total: 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T62S.080) M103755 070314
 Identify as D2278
 Batch: ~~XXXXXX~~ ML ~~XXXXXX~~

(40)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2278
 Dwg Rev: E
 Prog Rev: E

ML 070420

(40)

2-Deburr if necessary

ml 07/04/30 (x37)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 070420

(40)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

37
070424

(P70)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

ml 07/05/02

(39X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070424	4.0	1 part scrap, hole was incomplete	ASIA12	Destroy & No replace	SB 07/04/24	070424	ASIA12	070424

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 28791B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CP 04/05/02 (39)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 04/05/02 (39)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(39)

Comment: FINAL INSPECTION/W/O RELEASE

12/7/02

Job Completion



U 07-05-02

NOTE: H-I FORMS Quality Assurance

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

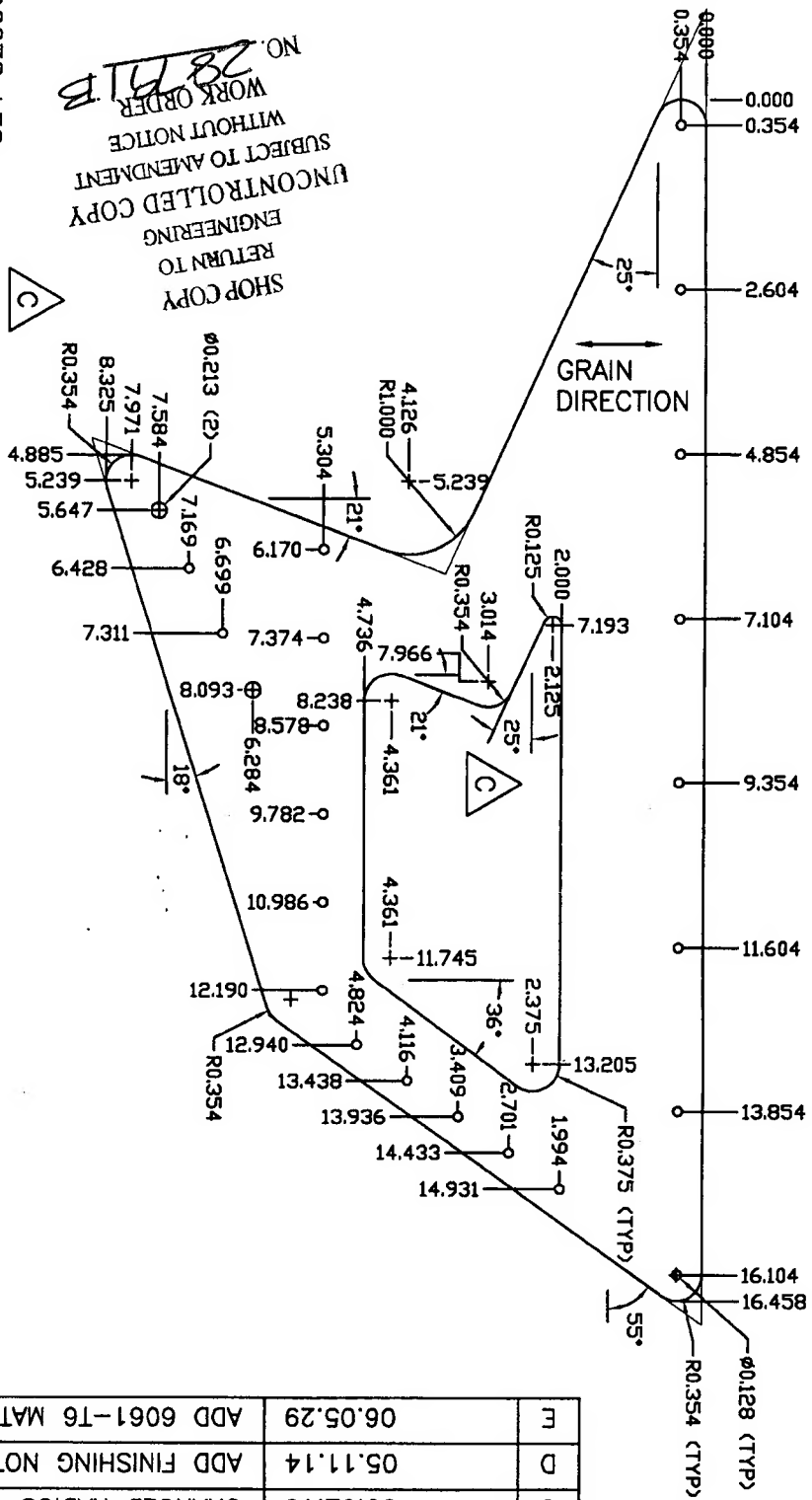
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

DART

RELEASED
06.06.20



D2278 LEG

- 1) MATERIAL:
6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR
5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 2) FINISH:
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BY BW	DRAWN BY CB	CHECKED PH	APPROVED [Signature]	DRAWING NO. D2278	REV. E SHEET 1 OF 1
DATE 06.05.29					
TITLE LEG					
SCALE 1:2.5					
C	95.02.16	CHANGED RADIUS TO 0.354			
D	05.11.14	ADD FINISHING NOTE			
E	06.05.29	ADD 6061-T6 MATERIAL			

DART AEROSPACE LTD		Work Order: 28791B
Description: Step leg		Part Number: D2278
Inspection Dwg: D2278 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.354	+/-0.010	0.352	✓		VERN	
B 0.354	+/-0.010	0.357	✓		VERN	
C 2.250	+/-0.005	2.251	✓		VERN	
D 16.458	+/-0.010	16.458	✓		Measuring tape	
E Ø 0.128	+0.005-0.001	0.128	✓		VERN	
F R0.354	+/-0.010	R0.354	✓		Radius Gauge	
G 2.000	+/-0.010	2.005	✓		VERN	
H 4.736	+/-0.010	4.734	✓		VERN	
I 8.325	+/-0.010	8.325	✓		VERN	
J Ø 0.213	+0.005-0.001	0.213	✓		VERN	
K 0.080 thick	+/-0.010	0.079	✓		VERN	
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ML ML	Audited by:	Prototype Approval: N/A		
Date: 07.04.20	Date: 07.04.24	Date: N/A		
Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

